

Work Order ID 50482

July 10, 2009 2:32:24 PM



Page 1

Item ID: D3830-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Item Name: Vertical Tunnel Upper, LH

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3830

A-PROTO 09.06.12

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/15 (X1)

M109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA054 using tool DT9318
Dwg Rev: A
Folio Rev: A

BB 09/07/16 (X1)

Work Order ID 50482



Page 2

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Item Name: Vertical Tunnel Upper, LH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	Hand Finishing Thermoforming	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg	0.00							

BB 07/09/16 (X1)

Sh 09/07/15 (X1)

Sh 09/07/15 (X1)

SECRET

Page 3

Accept

RESEARCH

Setup Start

Stop

11/11/2011

Cust Item ID:

1. The first step is to identify the problem. This involves understanding the current situation and what needs to be changed.

2. The second step is to set goals. These should be specific, measurable, achievable, relevant, and time-bound.

3. The third step is to develop a plan. This involves determining the steps that need to be taken to achieve the goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making any necessary adjustments.

5. The fifth step is to evaluate the results. This involves assessing the progress made and determining if the goals have been achieved.

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

150

QC2- Inspect parts off machine FAI/FAIB

0.00

DL. 09/07/15 (X)

QC

Memo

0.00

Quality Control

Complete FAI document

160..

QC5- Inspect part completeness to step on W/O

0.00

PH 09.07.20

**ENGINEERING
APPROVAL**

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

FOR
ENG'G
TEST

Packaging

Memorandum

0.00

Packaging

143

Work Order ID 50482

Page 4

July 10, 2009 2:32:24 PM

Item ID: D3830-1KIV

Accept



Setup Start

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Stop

Item Name: Vertical Tunnel Upper, LH



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.07.20 Prototype

By 24-07-09

Picklist Print

Page 1

July 10, 2009 2:32:24 PM

Work Order ID: 50482

Parent Item: D3830-1KIVRevA-PROTO

Parent Item Name: Vertical Tunnel Upper, LH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	1.5000			



6185 KYDEX .080"



Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

894.5037653

109703

894.503765

M109703

26x21 ÷ 2

DB

SEE W/O 50482

DART AEROSPACE LTD	Work Order: 58482
Description:	Part Number: D3230-1 KIU
Inspection Dwg: D3230-1 Rev: A PRATO	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

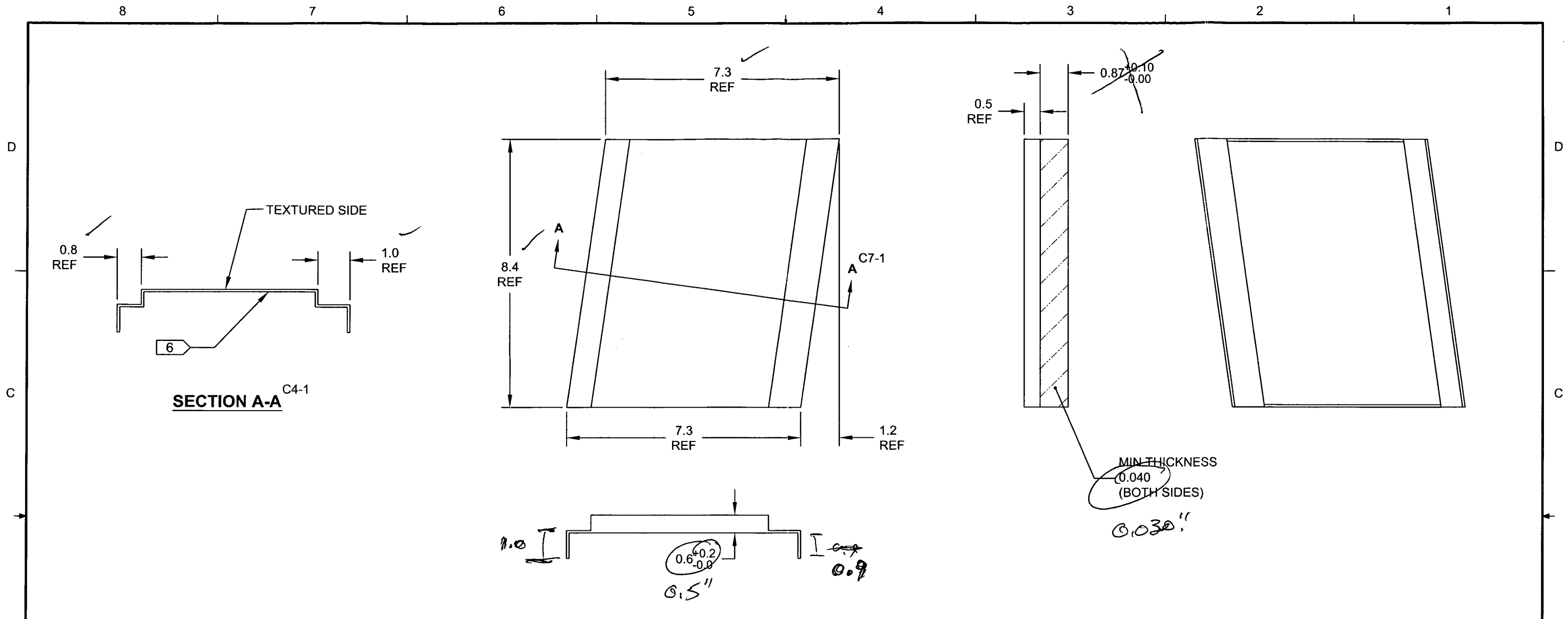
Measured by: BB	Date: 09/07/16
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50"	± .100	0.567	✓			
0.90"	± .100	0.698		✓		Deviation
1.0"	± .100	0.714		✓		Deviation
0.050"	MIN	0.068"	✓			
0.030" 0.035	MIN	0.036	✓	✗		

Measured by: D. Regier	Date: 09/07/15
Audited by: RJ	Date: 09.07.12
Prototype Approval: RJ	Date: 09.07.12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3830-1 VERTICAL TUNNEL, UPPER L/H

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.08

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.3 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9318 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3830-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3830-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

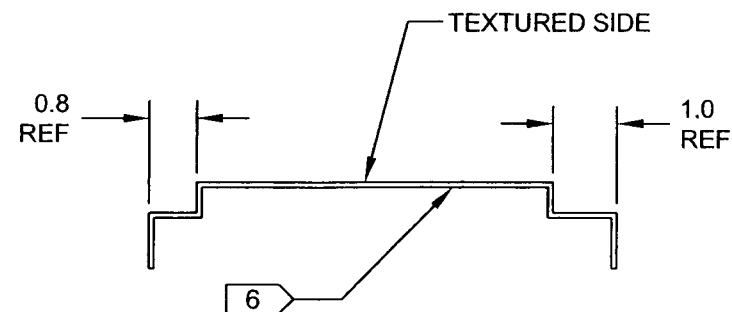
A	NEW ISSUE	PH	09.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3830	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (206 L3/L4)	NTS
DATE	09.06.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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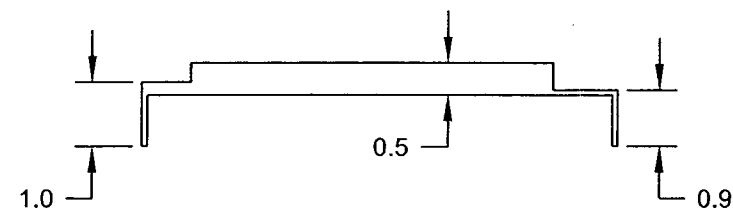
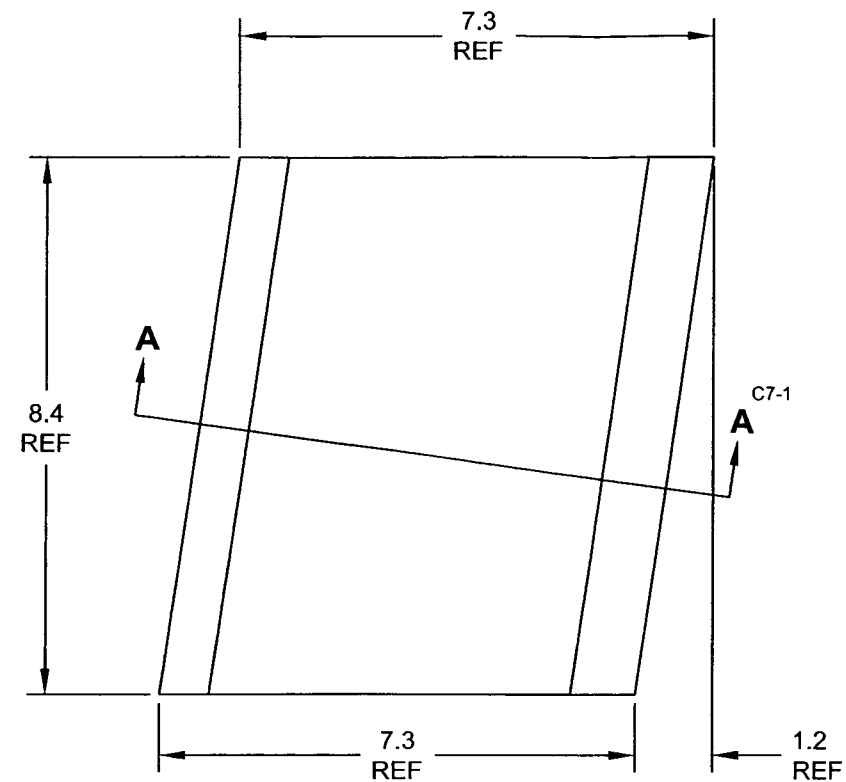
C

B

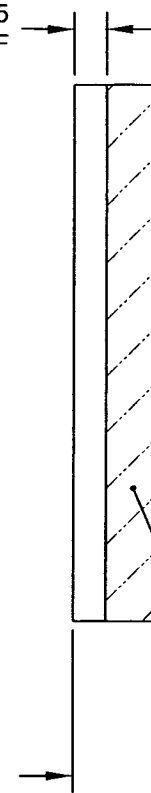
A



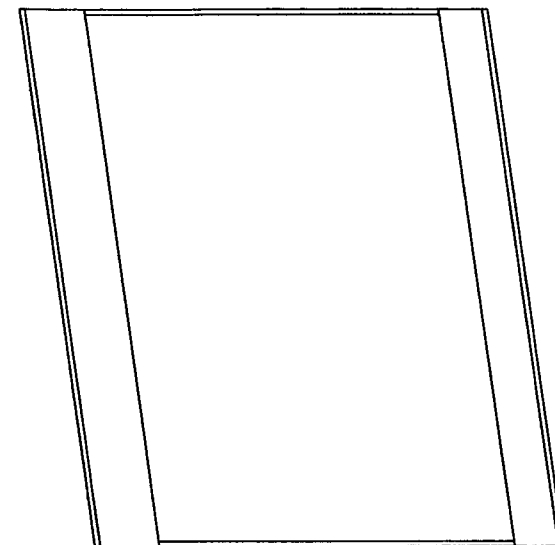
SECTION A-A C4-1



0.5
REF



MIN THICKNESS
0.035
(BOTH SIDES)



D3830-1 VERTICAL TUNNEL, UPPER L/H

NOTES:

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D3830-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.12
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DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. REV. A	
CHECKED		D3830 SHEET 1 OF 2	
MFG. APPR.		TITLE SCALE	
APPROVED		VERTICAL TUNNEL (206 L3/L4) NTS	
DE APPR.			
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